Dart Aerospace Ltd.

Date: Wednesday, 8/8/2007 1:23:27 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: FLOAT SKID RH 206L1,L3,L4&407
Job Number	: 33850		
Estimate Number	: 10328		
P.O. Number	: N/A	**Part Number**	: D206642512
This Issue	: 8/8/2007 **S.O. No.** : N/A	**Drawing Number**	: N/A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: K
Previous Run	: 33626	**Material**	: N/A
Written By	: 07-08-08	**Due Date**	: 8/15/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM est rev D 07.06.06 added K642-512 EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL — KS 07-08-27 (1)
	Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D206-642-512 CHG003	ER 01/9/12
2.0	33850A	FLOAT SKIDTUBE ASSEMBLY
	Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY D206-642-541 B B33850A	7/9/12 (1)
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
4.0	K642 512	saddle kit 642-511
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) saddle kit 642-512 batch: B 33665	7/9/12
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS — PTO → Last Page
	Comment: INSPECT 100% KITS FOR COMPLETENESS	ER 01/9/12

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B — Initial Chief Eng	Corrective Action Section B — Action Description Chief Eng	Corrective Action Section B — Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07/09/12	# 5.0	when final inspection of QC[illegible] was Done the Red Tag was found ~~to be~~ to Have the wrong Batch number on it B33[illegible]50 instead of B33850	[signature] 05/09/12	Remove and Replace with correct Red decale.	[signature] 4/9/12	[signature] 07/09/12	[signature] 05/09/12	[signature] 07/09/12
			✓	Re Print correct ~~Red~~ Red decale.	[signature] 07/09/12	[signature] 07/09/12	✓	✓

NOTE: Date & initial all entries

Date: Wednesday, 8/8/2007 1:24:35 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: FLOAT SKIDTUBE ASSEMBLY
Job Number	: 33850A		
Estimate Number	: 10309		
P.O. Number	: N/A	**Part Number**	: D206642541
This Issue	: 8/8/2007 **S.O. No.** : N/A	**Drawing Number**	: D3274 REV D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: D
Previous Run	: 33849A	**Material**	: N/A
Written By	: [signature] 07-08-08	**Due Date**	: 8/15/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D206-642-541 CHG003 N/A

2.0	D26001190	Extrusion Round 3" 206

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2600-1-190	3" OD Tube	B24841 [initials] 07-08-09

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

[initials] 07-08-09

Form: rprocess

Date: Wednesday, 8/8/2007 1:24:35 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33850A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

fm 07-08-09

Comment: HAND FINISHING RESOURCE #1
Acid Etch and Alodine tube as per QSI 005 4.1

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION DP 7-8-9

6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP DP 7-8-9

7.0	D3282041	I-Beam

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3282-041	Float Web	B-33656 AWM 07/08/13

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274 fm 07-08-09

2-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274 fm 07-08-09

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube fm 07-08-09

4-Bond web in place as per Dwg D3274 & QSJ 015.
A/R Sikaflex-291 M104989
Sikaflex expire date: 8-11
Start: 07/08/13 Time: 1:35
Finish: ~~07/08/13~~ Time: ~~1:50~~ AWM 07/08/13
(Adhere for 12 hours)
7-8-14 4:15PM

9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP DP 7-8-14

Form: rprocess

Date: Wednesday, 8/8/2007 1:24:35 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33850A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

5-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

6- Countersink crossbolt spacer holes as per Dwg D3274

JDP 7-8-14

R 7-8-15

Seq. #:	Machine Or Operation:	Description :
11.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/15

Seq. #:	Machine Or Operation:	Description :
12.0	D32851	Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3285-1	Fwd Cap	B33374

BE 07-08-20

Seq. #:	Machine Or Operation:	Description :
13.0	D2649	Crossbolt Spacer

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	D2649	Crossbolt spacer	B33214 (2PC) B31926 (10PC)

BE 07-08-20

Form: rprocess

Date: Wednesday, 8/8/2007 1:24:35 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** FLOAT SKIDTUBE ASSEMBLY

Job Number: 33850A **Part Number:** D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
14.0	D32751	Crossbolt Spacer

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:
Qty Part Number Description Batch
12 D3275-1 Crossbolt spacer B-33429 BE 07-8-20

15.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod. BE 07-8-20
A/R Aluminum Rod M 104221 / M 105058

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R Aluminum Rod M 104221 BE 07-08-20

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube [initials] 07-08-20 (1)

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr. [initials] 07-08-20 (1)

16.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP [initials] 07/08/23 (X1)

17.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION [initials] 07/08/24

18.0	POWDER COATING	POWDER COATING

M 105068

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 [initials] 07-09-04

19.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION [initials] 07/09/06 (1)

Form: rprocess

Date: Wednesday, 8/8/2007 1:24:35 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** FLOAT SKIDTUBE ASSEMBLY

Job Number: 33850A **Part Number:** D206642541

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
20.0	D3415041	Nut Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	D33434

FL

21.0	CCR264SS33	Cherry Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	m102525

FL

22.0	CR3212403	Cherry Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	D15918

FL

23.0	ALS71032130	Insert

Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)
Insert
Batch: m102475

FL

24.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/RN/ALPS-3 m104167

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a
A/R Sikaflex-291 m104989
Sikaflex expire date: 08-07

FL 07/09/06 ①

Form: rprocess

Date: Wednesday, 8/8/2007 1:24:35 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33850A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
Inspect Nut Plate & Inserts
Ir A07/06 (41)

Seq. #:	Machine Or Operation:	Description :
26.0	AN3C4A	BOLT

Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
BOLT
Batch: m105143
FL

Seq. #:	Machine Or Operation:	Description :
27.0	D353515	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B32737
FL

Seq. #:	Machine Or Operation:	Description :
28.0	D353523	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B32735
FL

Seq. #:	Machine Or Operation:	Description :
29.0	D353535	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B32736.
FL

Seq. #:	Machine Or Operation:	Description :
30.0	D353539	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B33629.
FL

Seq. #:	Machine Or Operation:	Description :
31.0	D353615	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: B32746
FL 07/09/07 (1)

Form: rprocess

Date: Wednesday, 8/8/2007 1:24:35 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33850A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
39.0	D34131	Ring

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3413-1	Ring	B33433

FL

Seq. #:	Machine Or Operation:	Description :
40.0	AN4C5A	BOLT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	AN4C5A	Bolt	m18918

FL

Seq. #:	Machine Or Operation:	Description :
41.0	AN960C416	washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	AN960C416	Washer	m100993

FL

Seq. #:	Machine Or Operation:	Description :
42.0	D2646	Aft Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B31335

FL

Seq. #:	Machine Or Operation:	Description :
43.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274
A/R Sikaflex-291 m104989
Sikaflex expire date: 08-01

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3
A/R LPS-3 Batch: m104161

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

FL 07/08/07 ①

Form: rprocess

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33850A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
	A/R Sikaflex-291 m.104989 Sikaflex expire date: ~~08-01~~ 08-01	FL 07/09/07
44.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/09/10
45.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and stock Location: PPP B33850	07/9/12
46.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/09/10

Job Completion 07-09-12

Form: rprocess

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CP	PH	
CHECKED	APPROVED	DRAWING NO. D3274 — REV. D — SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY — SCALE NTS

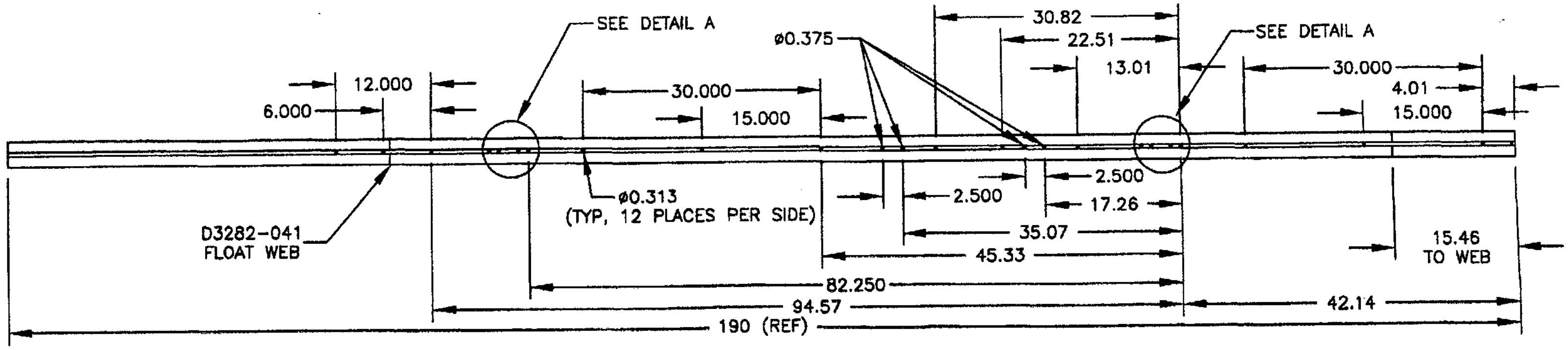
A	04.03.15	NEW ISSUE
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
C	05.03.16	ADD -043; NEW INSERTS
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

RELEASED
07.02.12

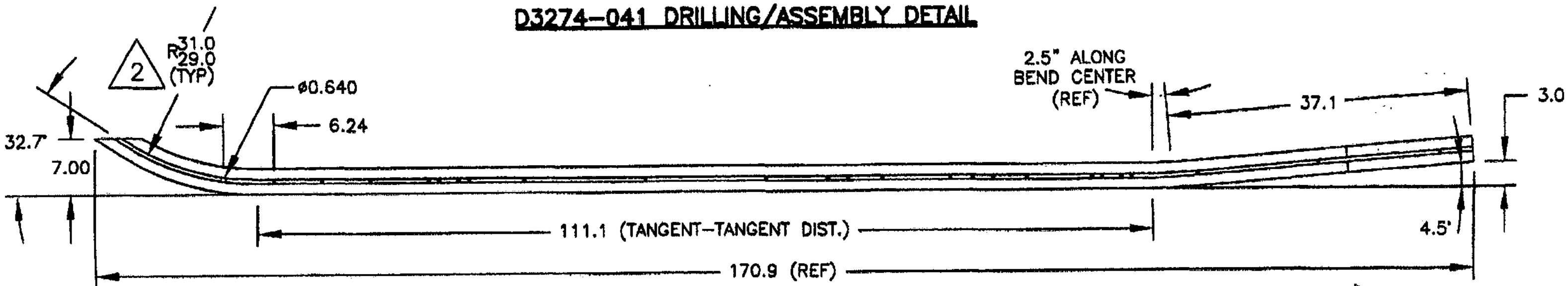
Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

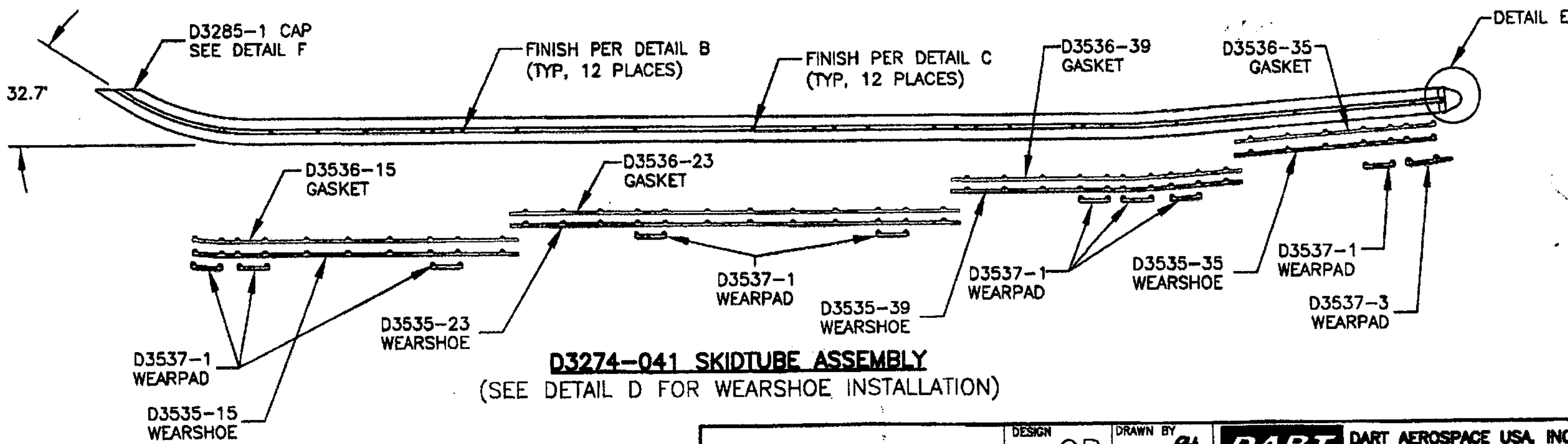
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
   - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.



D3274-041 DRILLING/ASSEMBLY DETAIL



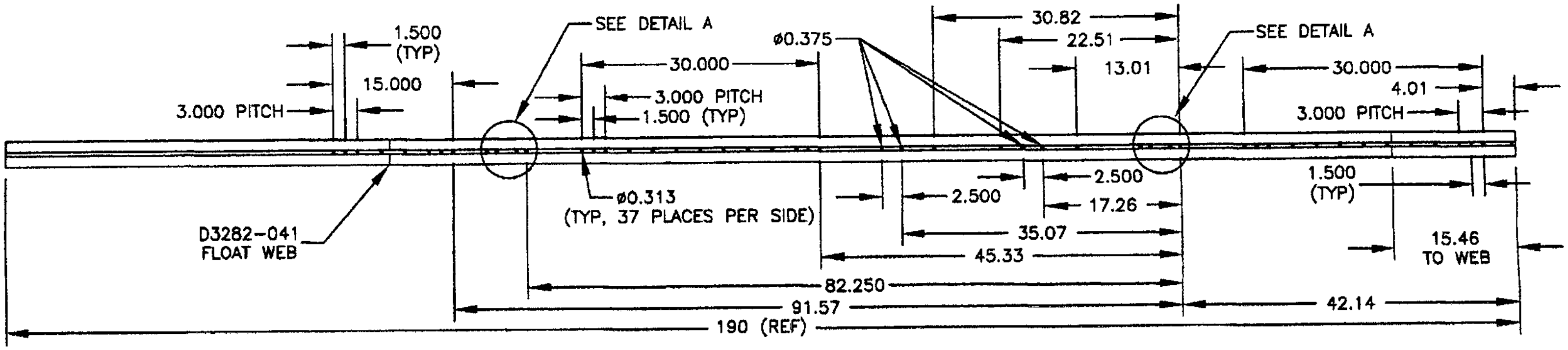
D3274-041 BEND/DRILLING DETAIL



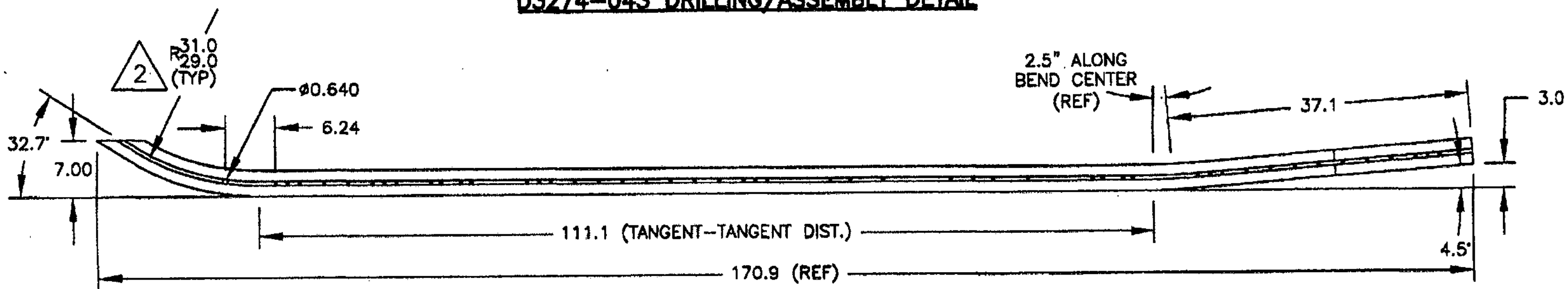
D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED
07.02.12

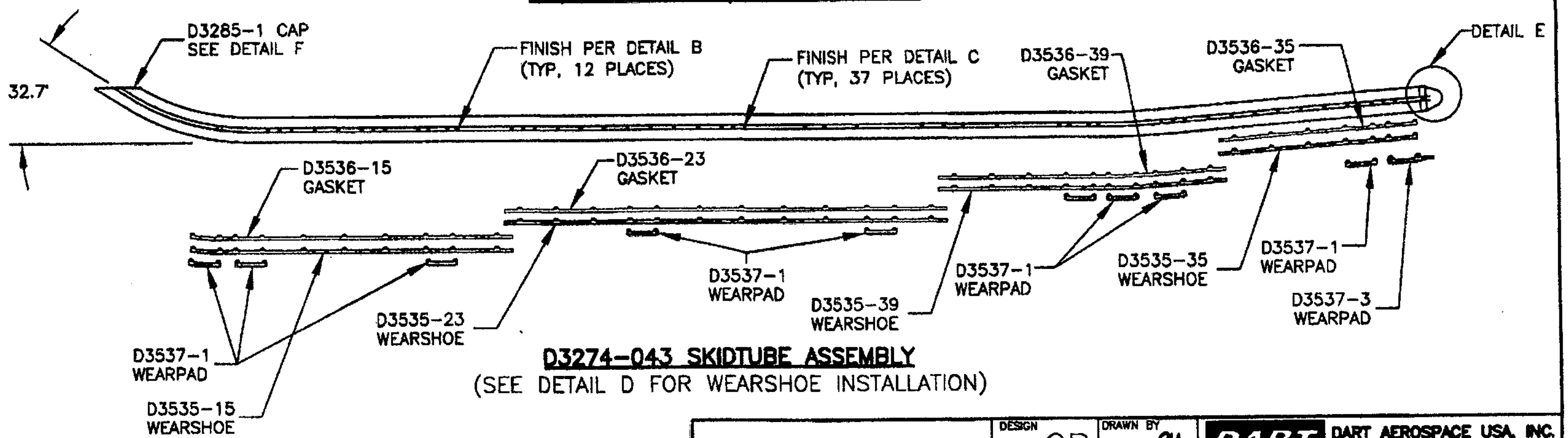
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CP	PH		
CHECKED	APPROVED	DRAWING NO. D3274	REV. D SHEET 2 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE 1:15



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



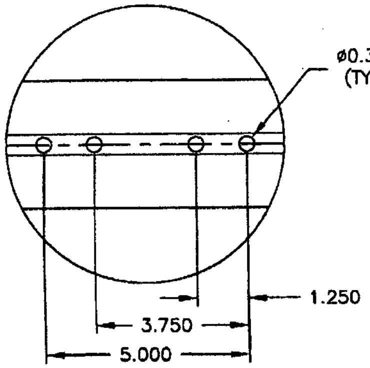
D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED 07.02.12

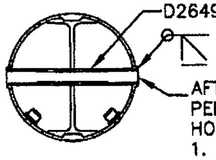
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CP	PH	
CHECKED	APPROVED	DRAWING NO. D3274 — REV. D — SHEET 3 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY — SCALE 1:15

DETAIL A: DRILL DETAIL



DETAIL B

FOR ø0.375 HOLES ONLY

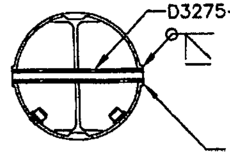


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.375 HOLES ONLY:

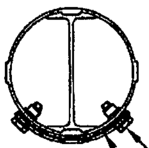
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO ø0.313x0.75 DEEP

DETAIL C

FOR ø0.313 HOLES ONLY



DETAIL D

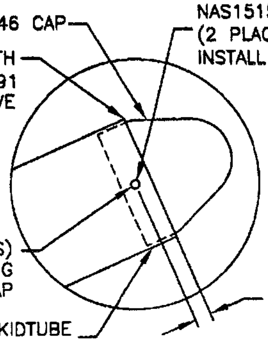


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

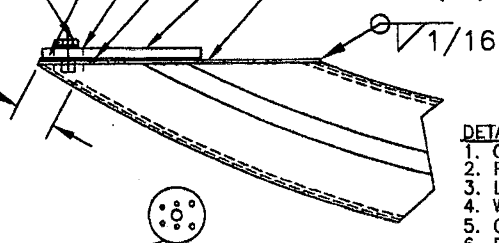
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E

AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291



DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

RELEASED 07.02.12

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CP	PH		
CHECKED	APPROVED	DRAWING NO. D3274	REV. D SHEET 4 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE 1:3

NO. 123

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A20664224/ /B330304

TEST WELDS REQUIRED

BASE METAL Alum
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS Tig
Single Weld [✓] ~~Double Weld~~ [ ]
Backing YES [ ] NO [✓]

	Position		Vertical Down [ ] Up [ ]	
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

Crossbolt Spacer Welded into ________ Skidtube

N/A

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/08/20 **Qualifier** [signature]